

Monday, September 11, 2017 10:59:12 AM

Kush today

Page 1

Approvals: _____ **Process Plan:**  **Date:** SEP 11 2017 **Tooling:** _____ **Date:** _____ **Run** **Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5012	C								

0.31

Hardinge CNC LATHE SMALL

Memo

2.38

1-Turn D5012 as per Folio
DWG REV: AA
FOLIO REV: C

DEBURR

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.20

Quality Control

DAS
23
9-89

17/9/12

DAS
23
9-89

17/9/12

Work Order ID 166108

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166108

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Item ID: D5012-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 9/18/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 9/18/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						<u>20</u>			DAS 14 9-89
QC	Memo	0.40							17/09/12
Quality Control									
130	Identify as per dwg & Stock Location: <u>SX130</u>	0.00							
130						<u>20</u>			SEP 12 2017 DAS
Packaging	Memo	0.20							6 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									17/9/19
QC	Memo	2.00							
Quality Control									

 SEP 12 2017

Picklist Print

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Work Order ID: 166108

166108

Parent Item: D5012-1

D5012-1

Parent Item Name: Spacer

Start Date: 9/18/2017

Required Date: 9/18/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 13-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.500		Purchased		No		100	f	62.5500	0.025	0.526316			

MDFI RINR0 500

**

Delrin Round Bar .50" color: black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT039	62.55	
m126369	46.55	
m135422	16	

0.725

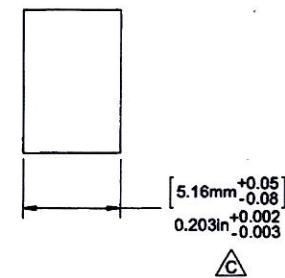
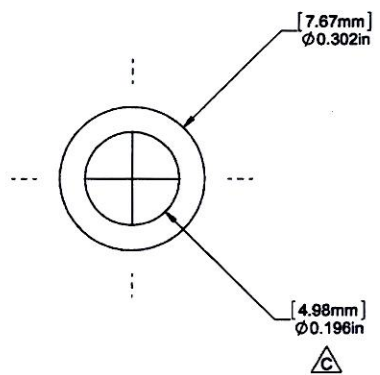
DAS
23
9-89

17/9/12



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166108

SEP 11 2017



D5012-1 SPACER

RELEASED
2014-07-28

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5012-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING A REMOVABLE TAG, PER QSI 044 METHOD 6.6
- 7) WEIGHT: 0.0005 lbs (0.0002kgs)

C	REVISED D5012-1 SPACER DIMENSION (ZN B3-1, ZN B5-1). UPDATED NOTE 7 (ZN A8-1)	AK	14.07.14
B	REVISE NOTE 6) (ZN A8-1)	AK	14.06.05
A	NEW ISSUE	DC	13.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5012	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SPACER	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED